



7761

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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RB T103065
Job Sheet 184407



Part No: RB T103065

Job Qty: 3 pcs

Part Name: Tail Rotor Drive Shaft Bearing Hanger Locator



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/9/18

Job Tracking No:

Due Date: 12/12/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RB T103065 Rev. B IPP Rev. A 18.09.25 New issue DP Verify DD/IPP Rev. B 19.01.14 drawing revision
DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	3 pcs	12/12/18		0.00	0.75	Small Fab - 1		
							Small Fab - 2		MLC
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	3 pcs	12/12/18		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		DAS
							QC 5 - 38		38
							QC 5 - 42		9-89
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 3-1 - Stock - B4B	3 pcs	12/12/18		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		



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CANADA
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Container No: S148317



Part: RB T103065

Job No: 184407

Serial No/Batch: S148317

Revision: B

Inspector:

Exp Date:

Instructions:

Date: 01/28/19

				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - FG	3 pcs	12/12/18	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70

DAS
28
9-89

DAS
21
JAN 28 2019

Part Op **110** - Small Fab-3 (Small Fab) 1-Assemble as per DWG. Press fit -5 and -7 bushings as per DWG. See note 10.
Descriptions: **120** - QC5 (QC5- Inspect part completeness to step on W/O)
130 - Packaging3-1 (Identify as per dwg & Stock Location: _____) The tool must be packaged with a desiccant bag into a tight fitting sealed plastic bag as per DWG.
140 - QC21 (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
CL-20-JP	Pin	6 Ea (2 ea)	110-Small Fab - 1	5124280
RB T103065-3	Support	3 Ea (1 ea)	110-Small Fab - 1	5145623
RB T103065-5	Insert	6 pcs (2 ea)	110-Small Fab - 1	5142589
RB T103065-7	Bushing	6 pcs (2 ea)	110-Small Fab - 1	5142582

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	CL-20-JP	6	10	0
	RB T103065-3	3	8	0
	RB T103065-5	6	8	0
	RB T103065-7	6	8	0

Part Specifications	
Specifications could not be found.	



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Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/9/18

Job Tracking No:

Due Date: 12/12/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG T103065 Rev. A IPP Rev. A 18.10.01 New issue DP Verify DD

Ship Via:

Reprint

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	3 Ea		12/12/18	0.00	0.00	Start Up Small Fab-2		
110	Small Fab	3 pcs		12/12/18	0.00	0.75	Small Fab-3		
120	QC	3 pcs		12/12/18	0.00	0.00	QC5		
130	Packaging	3 pcs		12/12/18	0.00	0.00	Packaging3-1		
140	QC21-FG	3 Ea		12/12/18	0.00	0.00	QC21		

Part Op 110 - 1-Assemble as per DWG. Press fit -5 and -7 bushings as per DWG.

Descriptions: 130 - The tool must be packaged with a desiccant bag into a tight fitting sealed plastic bag as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
CL-20-JP	Pin	6 Ea (2 ea)	90-Start up Operation	
RB T103065-3	Support	3 Ea (1 ea)	110-Small Fab	
RB T103065-5	Insert	6 pcs (2 ea)	110-Small Fab	
RB T103065-7	Bushing	6 pcs (2 ea)	110-Small Fab	

Job Allocations

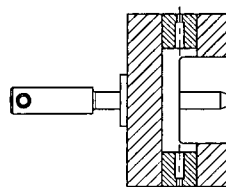
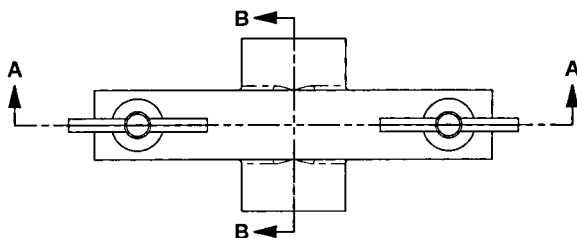
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	CL-20-JP	6	10	0
110-Small Fab	RB T103065-3	3	0	0
	RB T103065-5	6	8	0
	RB T103065-7	6	8	0

Part Specifications

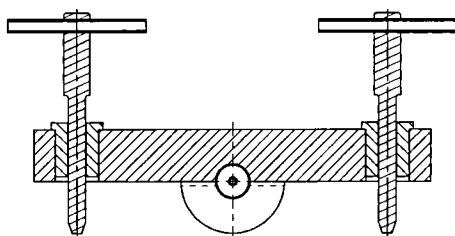
Specifications could not be found.

Plex 1/14/19 1:14 PM dart.leclair.mathieu

ITEM #	QTY	PART #	PART TITLE
-3	1	RB T103065-3	SUPPORT
-5	2	RB T103065-5	INSERT
-7	2	RB T103065-7	BUSHING
8	2	CARRLANE#CL-20-JP OR EQUIV.	STEEL JIG PIN 1/4" DIA. X 2" LG.



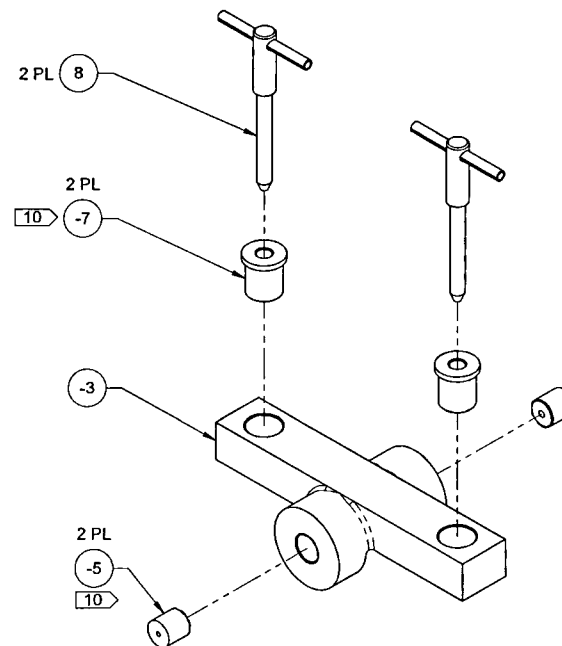
SECTION B-B



SECTION A-A

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1^\circ$
X.XX = $\pm 0.01"$ / $\pm 0.5^\circ$
X.XXX = $\pm 0.005"$ / $\pm 0.1^\circ$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) ASSEMBLE AS SHOWN
- 9) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG
- 10) APPLY LOCTITE 620 OR EQUIVALENT ON MATING SURFACES THEN PRESS FIT ITEMS -5 AND -7 WITH ITEM -3 AND REMOVE EXCESS



RB T103065 T/R DRIVE SHAFT BEARING HANGER LOCATOR

B	-3 MATERIAL WAS 2024-T3 IS 6061-T6 WITH ANODIZE BLACK FINISH, DIM WAS $\varnothing 0.5000/0.4888$ IS $\varnothing 0.5000+0.0000/-0.0005$, DIM WAS $\varnothing 0.6250/0.6238$ IS $\varnothing 0.6250+0.0000/-0.0005$, ADDED 0.02 X 45.0° CMF A PL			19-501	KPT
	-5 MATERIAL WAS 4130 IS 303/304/316, DIM WAS $\varnothing 0.5004/0.5002$ IS $\varnothing 0.5000+0.0005/-0.0000$, DIM 0.02 X 45.0° CMF ADDED.				
	-7 MATERIAL WAS 4130 IS 303/304/316, DIM WAS $\varnothing 0.6254/0.6252$ IS $\varnothing 0.6250+0.0005/-0.0000$, DIM 0.02 X 45.0° CMF ADDED.				
A	New Issue			N/A	N/A
REV.	DESCRIPTION			ECN #	BY
DESIGN	KPT			DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT				
CHECKED	KPT			TOOL PART #	REV. B
MFG. APPR.	FK			RB T103065	SHEET 1 OF 4
APPROVED	<i>M. Lee</i>			TITLE	SCALE
				T/R DRIVE SHAFT BEARING HANGER LOCATOR	NTS
DATE	1/13/2019			COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	